

DART AEROSPACE LTD.	Work Order:	21519
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	EP	04.09.17	12
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B320984	EP	04/11/22	12
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B320983	EP	04/11/22	12
4	MV	Fixturing W/O No. <u>N/A</u> Fixturing Inspection last completed <u>01/11/22</u> by <u>EP</u>	EP	04/11/22	12
5	MV	Program Batch No. <u>B21515</u> Double check by: <u>EP</u>	EP	04/11/22	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	01/11/30	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/11/30	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/11/30	12
9	MV	Machine keyway as per dwg D2571 & D2572	EP	04/11/30	12
10	MV	Deburr and remove all machining marks	EP	04/11/30	12
11	MV	Tumble for 20 minutes to remove sharp edges <u># 04.00.21</u>	EP	04/12/01	12
12	QC1	Inspect all dimensions to dimension sheets	EP	04/12/01	12
13	QC7	Second inspection	EP	04.12.01	12
14	FP	Acid etch and alodine as per QSI 005 4.1	MM	04/12/03	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MM	04/12/06	12
16	QC3	Inspect Powder Coat	EP	04/12/06	12
17	ST	Identify and Stock.	EP	04/12/06	12
18	AC	Cost / Part <u>115.99</u> <u>93.64</u>	SM	04-12-07	12
19	DC	Close W/O <u>113.68</u> <u>93.64</u> Inspection Level 21	EP	04.12.09	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ	

RELEASED
02/10/15